

Date: Monday, 23/02/2009 3:54:41 PM
 User: Linda Lacelle

Process Sheet

SP/17

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARING ASSEMBLY
Job Number	: 46031-1		
Estimate Number	: 10716		
P.O. Number	:	Part Number	: D3121241
This Issue	: 23/02/2009 S.O. No. :	Drawing Number	: D3121 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: E
Previous Run	: 45867	Material	:
Written By	:	Due Date	: 10/03/2009
Checked & Approved By	:	Qty:	67
Comment	: Est Rev:A 04.02.18 New issue KJ/DS Est Rev:B ECN 1060 07-11-12 DD verified by:EC	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :/	
1.0	MDELRINR12500	DELRIN ROUND BAR 1.25"	
	Comment: Qty.: 0.0546 f(s)/Unit Total : 3.2760 f(s) Material: Ø1.25 Delrin Rod (M-DELIN-R1.2500)Identify as D3121-25 Batch: 1110256		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
	Comment: HARDINGE CNC LATHE SMALL		
	1-Turn D3121-25 Cap as per Folio FA387		
	2-Deburr		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK	
	Comment: SECOND CHECK		
5.0	D312123	Bearing	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s) Pick: Qty Part Number Description Batch		
	1 D3121-23 Bearing 043550		

Process Sheet

Drawing Name: BEARING ASSEMBLY

Customer: CU-DAR001 Dart Helicopters Services

Part Number: D3121241

Job Number: 46031

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

INSPECT WORK TO CURRENT STEP

7.0 QC5



Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FINAL INSPECTION/W/O RELEASE

235A

9/3/4

SD

9.0 QC21



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 09.03.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3121-241 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 09/03/05

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 46031		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
7/3/04	6.0	Found one (Qty x1) Bearing Damaged. P.C. either installing the tire or manufacture.	/ QS1012	Bearing is scrap Qty x1 no replace.	EJ 09/03/04	S 02/03/05	/ QS1012	S 09/03/04

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	46031
Description: Cap	Part Number:	D3121-25
Inspection Dwg: D3121	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

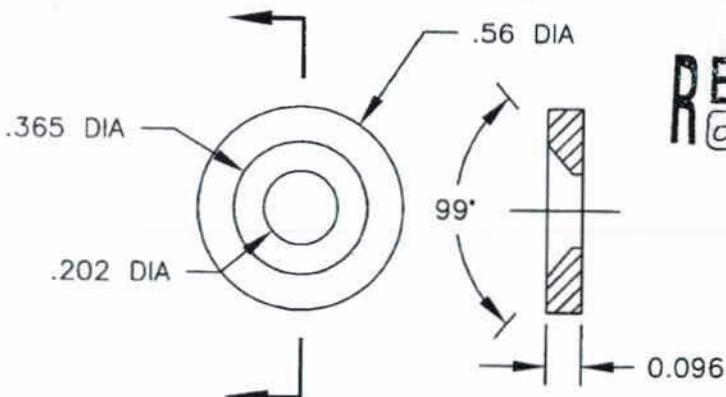
First Article Prototype

Measured by:	<i>JNL</i>	Audited by:	<i>SV</i>	Prototype Approval:	N/A
Date:	09/03/03	Date:	09/03/03	Date:	N/A

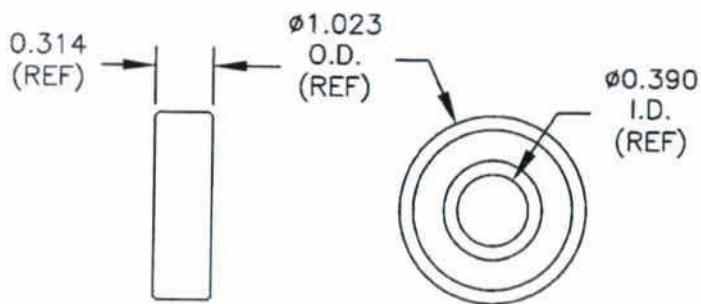
Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3121-241)	KJ/RF	
B	06.06.09	Ø1.000 diameter was Ø1.024	KJ/JLM	
C	08.01.16	Dwg Rev. updated	KJ/EC/DD	

DART

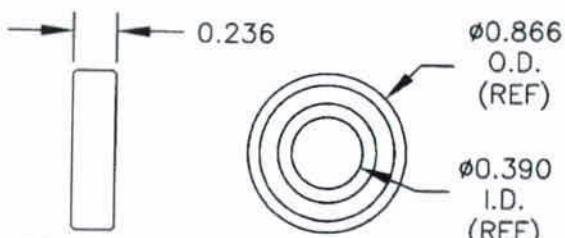
DESIGN <i>CH</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CH</i>	APPROVED <i>-H-</i>	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY	SCALE 1:1	

**D3121-17 WASHER (SCALE 2:1)**

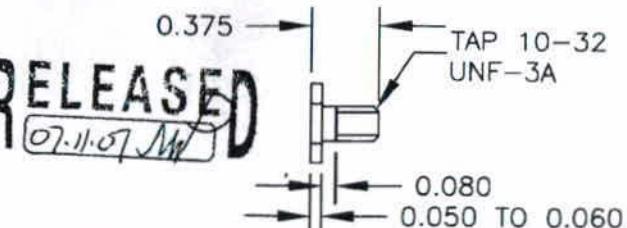
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

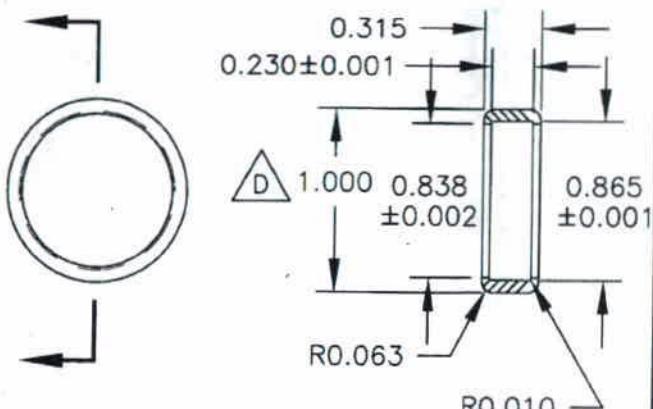
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

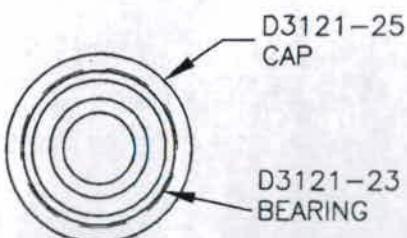
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**